



Dart Aerospace Ltd.
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Canada

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D350-591-312
Job Sheet 198864



Part No: D350-591-312

Job Qty: 10 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Due Date: 11/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	11/5/19		0.00	10.00	Large Fab - 1		<i>Stes</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	QC 9	10 pcs	11/5/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24	DAS	
							QC 9 - 43	24	
							QC 9 - 50	9-89	
							QC 9 - 9		
130	QC 5	10 pcs	11/5/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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140 Handfinish - 1-1 Chemical-B4B	10 pcs	11/5/19	0.00	1.87	QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
					OCT 21 2019	
150 QC 7	10 pcs	11/5/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					OCT 22 2019	
					DAS 81 9-89	
180 Large Fab - Steps - 2 - B4B	10	11/5/19	0.00	10.00	Large Fab - 1 - B4B	

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						Large Fab - 10 - B4B	
						Large Fab - 2 - B4B	
						Large Fab - 3 - B4B	
						Large Fab - 4 - B4B	
						Large Fab - 5 - B4B	
						Large Fab - 6 - B4B	
						Large Fab - 7 - B4B	
						Large Fab - 8 - B4B	
						Large Fab - 9 - B4B	
						Large Fab - 11 - B4B (Various)	
190	QC 10	10 pcs	11/5/19	0.00	0.00	QC 10 - 10	
						QC 10 - 18	
						QC 10 - 24	
						QC 10 - 43	
						QC 10 - 50	
						QC 10 - 58	
						QC 10 - 9	
200	QC 5	10 pcs	11/5/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
210	Handfinish - 1-2- Chemical- B4B	10 pcs	11/5/19	0.00	1.87	Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	

SLa

DAS
OCT 24 2019 68
9-89

DAS
OCT 24 2019 68
9-89

SLA OCT 24 2019

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220	Powdercoat - 1 White Gl(A)- B4B	10 pcs	11/5/19	0.00	2.98	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	B4B 14-10-25
						Powdercoat - 4 - B4B	
230	Handfinish - 3-1- WingWalk- B4B	10 pcs	11/5/19	0.00	1.87	Handfinish - 3 - 1 - B4B	HL 14-10-25
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
240	QC 3	10 pcs	11/5/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	DAS OCT 30 2019 68
						QC 3 - 9	9-89
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
250	Packaging 1-1 - Pick Kit - B4B	10 pcs	11/5/19	0.00	0.00	Packaging 1 - 1 - B4B	
						Packaging 1 - 2 - B4B	
						Packaging 1 - 3 - B4B	DAS
						Packaging 1 - 4 - B4B	74
						Packaging 1 - 5 - B4B	9-89
						Packaging 1 - 6 - B4B	
						Packaging 1 - 7 - B4B	
						Packaging 1 - 8 - B4B	
						Packaging 1 - 9 - B4B	
						Packaging 1 - 10 - B4B	
						Packaging 1 - 11 - B4B	
						Packaging 1 - 12 - B4B	
						Packaging 1 - 13 - B4B	
						Packaging 1 - 14 - B4B	
						Packaging 1 - 15 - B4B	
						Packaging 1 - 16 - B4B	
						Packaging 1 - 17 - B4B	
						Packaging 1 - 18 - B4B	
						Packaging 1 - 19 - B4B	
						Packaging 1 - 20 - B4B	
						Packaging 1 - 21 - B4B	
						Packaging 1 - 22 - B4B	
						Packaging 1 - 23 - B4B	
						Packaging 1 - 24 - B4B	
						Packaging 1 - 25 - B4B	
						Packaging 1 - 26 - B4B	
						Packaging 1 - 27 - B4B	
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260 QC 4	10 pcs	11/5/19	0.00 0.00	Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
				QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
270 Packaging 3-1 - Stock - B4B	10 pcs	11/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	10 pcs	11/5/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
280 QC 21 - FG	10 pcs	11/5/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	

DAS
78
9-89
NOV 01 2019

DAS
78
9-89
NOV 01 2019

DAS
21
9-89
NOV 04 2019

DAS
21
9-89
NOV 04 2019

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 3-Grind End Plate flush

120 - QC9- Inspect visual per QSI004- Fusion Welds

130 - QC5- Inspect part completeness to step on W/O

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

180 - Weld per dwg A/R Aluminum rod Batch: 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

190 - QC10- Inspect visual per QSI004- ground welds

200 - QC5- Inspect part completeness to step on W/O

210 - Chemical Conversion Coat per QSI005 4.1

220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 14/0 OVEN TEMPERATURE: 320

FINISH TIME: 2:10 11/21/86

230 - Wing Walk as per dwg QSI005 4.4 Batch

240 - QC3- Inspect Part Finish

250 - pick kit

260 - QC4- 100% Inspect kits for completeness

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

280 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	5220700
D3219-1	Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	5207455
D3272-1	Step	10 pcs (1 ea)	110-Large Fab - Steps - 1	5221207
D3065-041	Step Leg Assembly	10 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	5223665/5224473
D3066-1	Spacer	20 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	5199132
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	5141237
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5225333
AN4-12A	Bolt	80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5228670
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5190003
D2230-3	Mounting Lug	40 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5225226
D2218	Bushing	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5216129
D2256 400 720	Abrasion Strip 4" X 7 20"	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5222318
D2235-1	Mounting Lug	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5216668
D2278-041	Support Assembly	10 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5221605 V9 5226019 x 1
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5211533
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5225610
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5214649
NAS1149D0363.I	Washer	40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5222680
NAS1149D0463.I	Washer	160 Ea (16 ea)	250-Packaging 1-1 - Pick Kit - B4B	5225505
NAS1149D0563.J	Washer	40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5174288

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#110 12465

#180 12570

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	20	203	0
	D3219-1	20	95	0
	D3272-1	10	10	0
180-Large Fab - Steps - 2 - B4B	D3065-041	10	23	0
	D3066-1	20	257	0
	MS20600-AD4W4	160	1,408	0
	AN3-35A	20	324	0
250-Packaging 1-1 - Pick Kit - B4B	AN4-13A	80	1,260	0
	AN5-36A	20	219	0
	D2230-3	40	648	0
	D2618	20	208	0
	D2856-400-720	20	24	0
	D3235-1	20	287	0
	D3278-041	10	10	0
	MS21042L3	20	685	0
	MS21042L4	80	3,035	0
	MS21042L5	20	387	0
	NAS1149D0363J	40	1,694	0
	NAS1149D0463J	160	4,174	0
	NAS1149D0563J	40	2,029	0
Part Specifications				
Specifications could not be found.				

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

DEPARTMENT/PROCESS

Part No.

DISPOSITION

Rework	Scrap	Use-as-is

Skid-tube		
Machining		
Large Fab		

Cross tube	Small Fab	Finishing

Eng. (Non-AW)
Prod. Eng. Coord.
Rec./Store/Packaging

Engineering	Water Jet	Supplier	Quality
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MARB (QSI042)

Date:	Sequence #:
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QTY Affected :

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator	
Manufacturing Process	
Equip/Tooling	
Handling/Preservation	
Material	
Product Improvement	
Process Improvement	
Human Factors	

Pressure/Forced
Bending
Crushing
Cracks
Crimp/Kink/Ripple
Marks/Chatter
Mislabeled

Other/Details:

FAULT CATEGORY

Contamination
Misaligned/off
BOM/Route
Broken/Damaged
Incomplete/Un
Drill Holes
Fit/Function

Power Loss/Surge
Folio/Program
Grain Direction
Weld
Wrong Stock Pulled
Out of Sequence
Off-set/Set-up

	Positioned Wrong
	Outside Tolerance
	Drawing
	Finish
	Part Lost/Missing
	Misread

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Hel-Access-Step™, Short Step - High Skid, LH
	X					D350-591-214	Hel-Access-Step™, Short Step - High Skid, RH
		X				D350-591-215	Hel-Access-Step™, Short Step - Low Skid, LH
			X			D350-591-216	Hel-Access-Step™, Short Step - Low Skid, RH
				X		D350-591-311	Hel-Access-Step™, Long Step - High Skid, LH
					X	D350-591-312	Hel-Access-Step™, Long Step - High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2958-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-38A	BOLT
4	4	4	4	4	4	NA81149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NA81149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NA81149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.